

Work Order ID 136055

Thursday, August 27, 2015 1:30:09 PM

136055

Page 1

Item ID: D3183-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing
Start Date: 8/27/2015 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 8/27/2015 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: MCS Date: AUG 27 2015 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3183	Rev C1								

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 29653 Bearing as per Dwg D3183 Single row, deep groove, Conrad type, shielded Possible Supplier: NSK P/N 6800ZZ Certificate of conformity note is required
CY SEP 02 2015 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.02
Packaging Ensure certificate of conformity is attached
SEP 02 2015 50 DAS 08 9-89

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control 50 SEP 02 2015 DAS 38 9-89

Work Order ID 136055

Thursday, August 27, 2015 1:30:09 PM

136055

Page 2

Item ID: D3183-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing
Start Date: 8/27/2015 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 8/27/2015 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>slow</u>	0.00							
130									
Packaging	Memo	0.01				SO	27		
Packaging								SEP 08 2015	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08				MW		SEP 04 2015	
Quality Control									

20150904
SA

Thursday, August 27, 2015 1:30:13 PM

Page 1

136055

D3183-5

Required Date: 8/27/2015

Required Qty: 50.00

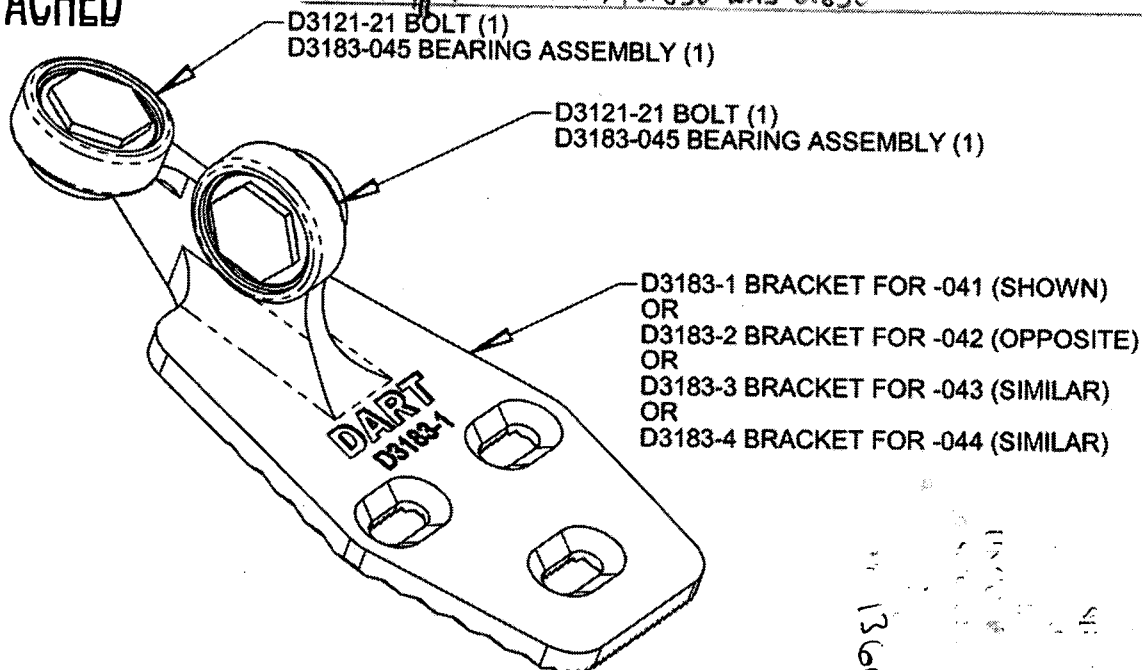
Comments: IPP: A03.03.27New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6800ZZ *680077* Bearing		Purchased	No			100	Each	0.0000	1	50			
									**			SEP 02 2015	

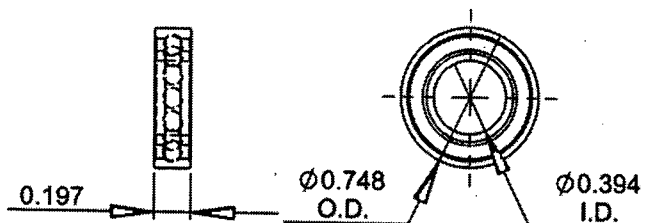


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1	
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01
DEO ATTACHED

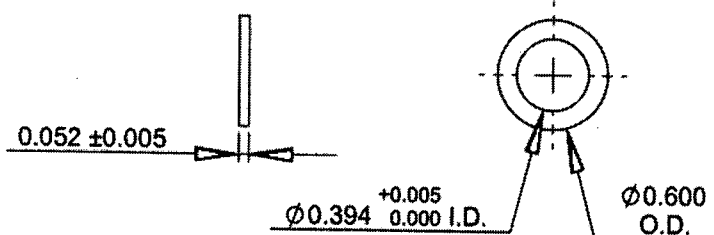


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

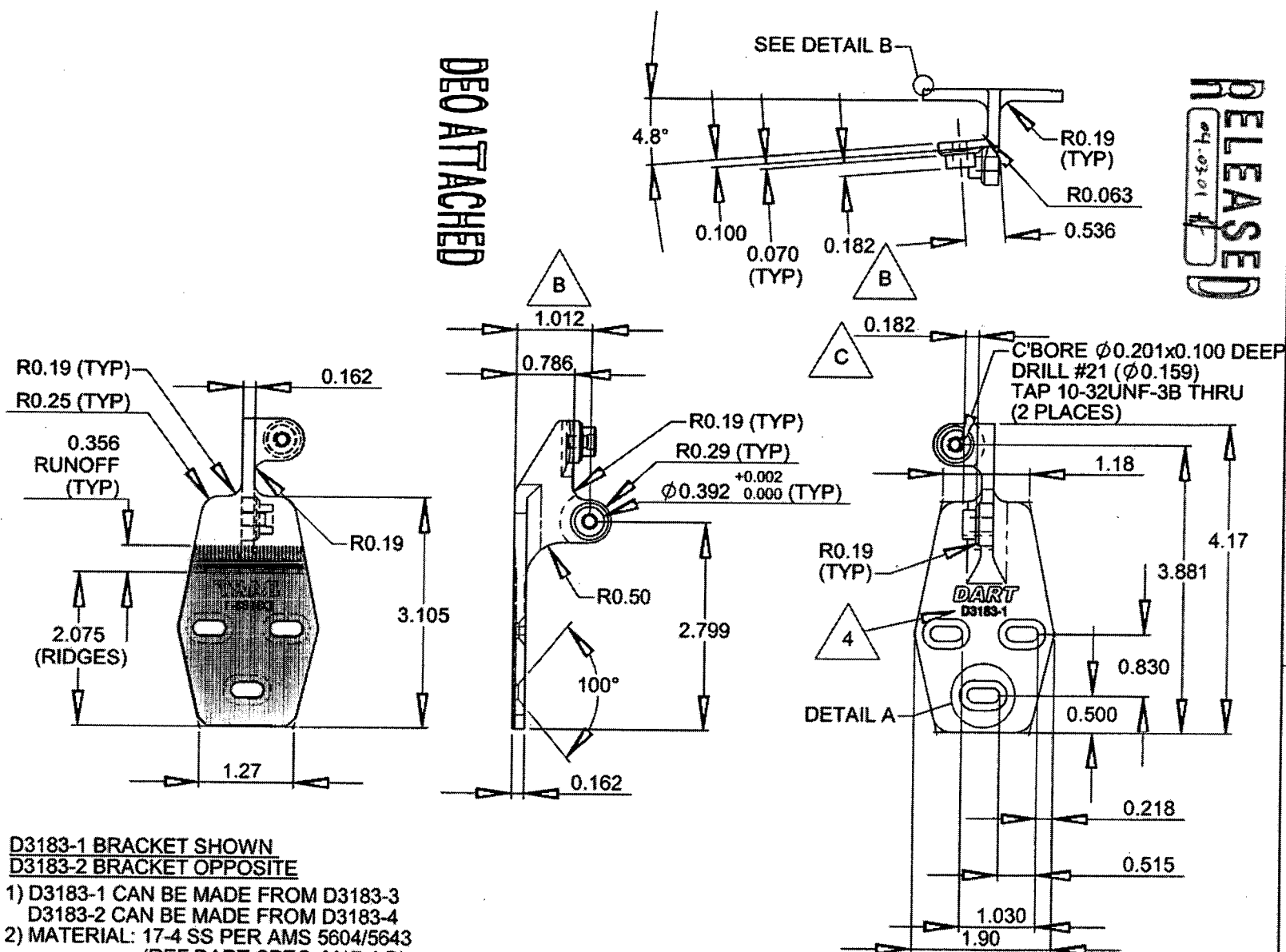
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 2 OF 4
TITLE	SCALE	
BRACKET ASSEMBLY	1:2	

RELEASED
04.03.01

DEO ATTACHED



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

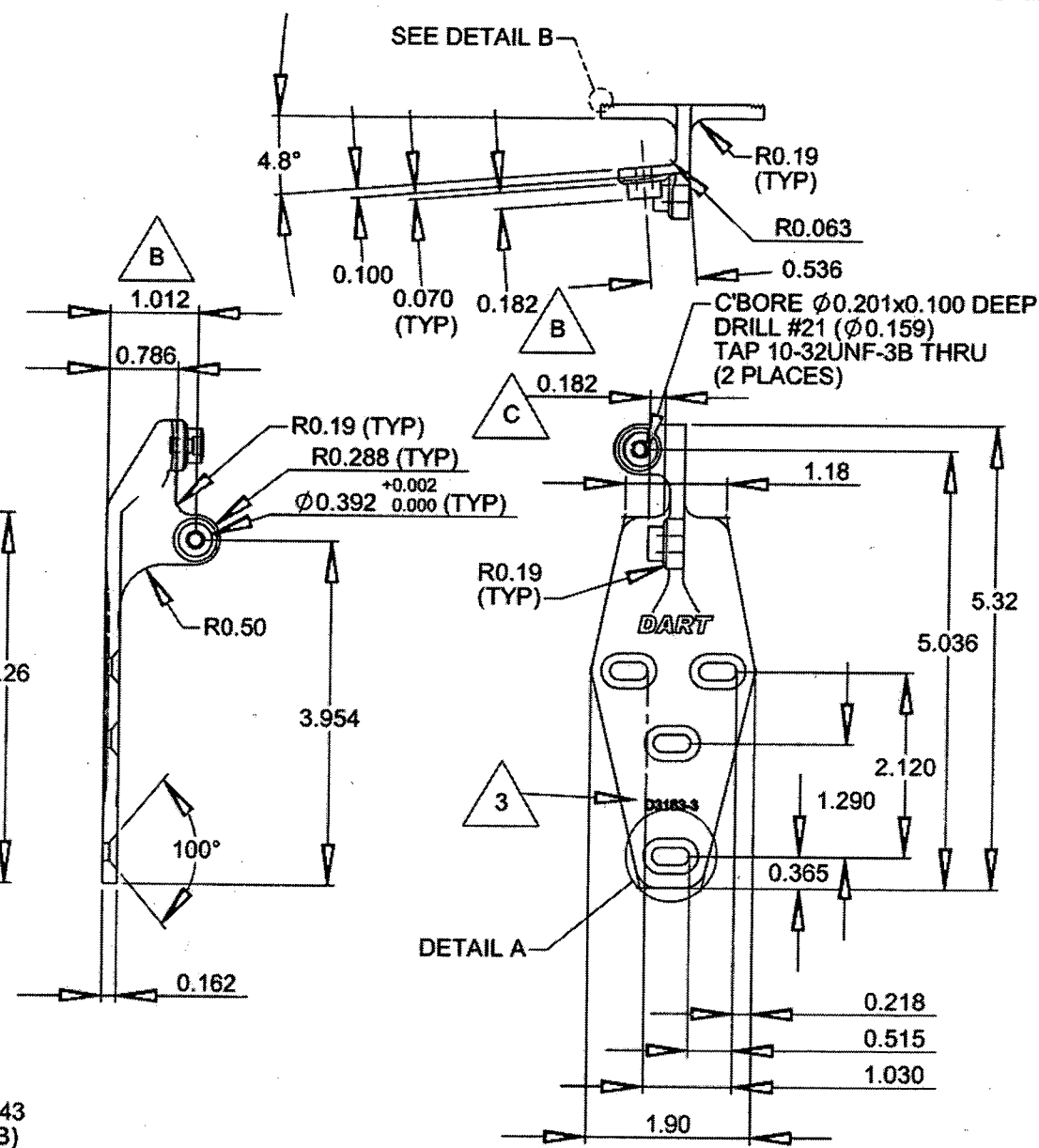
- 1) D3183-1 CAN BE MADE FROM D3183-3
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE STRENGTH = 150 ksi MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

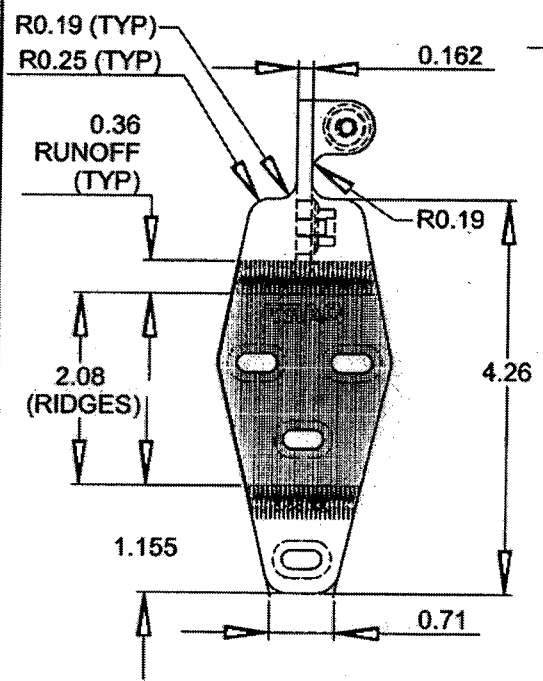
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

GA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3183	SHEET 3 OF 4
04.02.17		TITLE	SCALE
		BRACKET ASSEMBLY	1:2



DEO ATTACHED
RELEASED
APR 23 1961

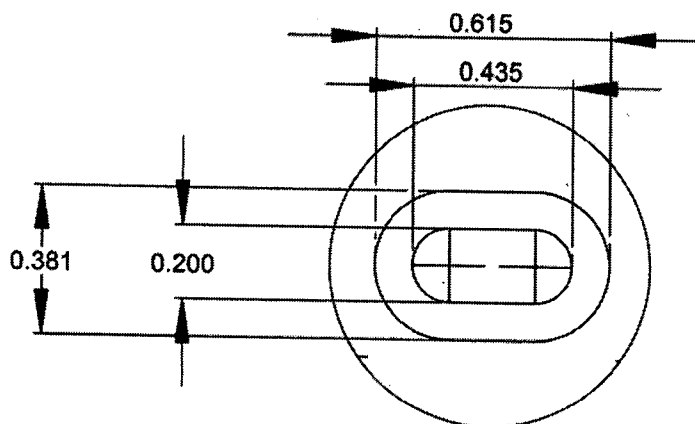


D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

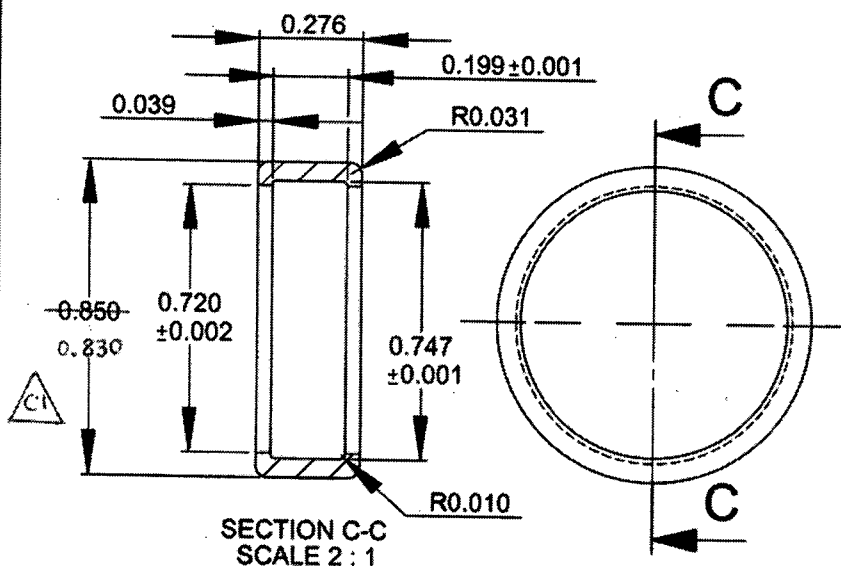
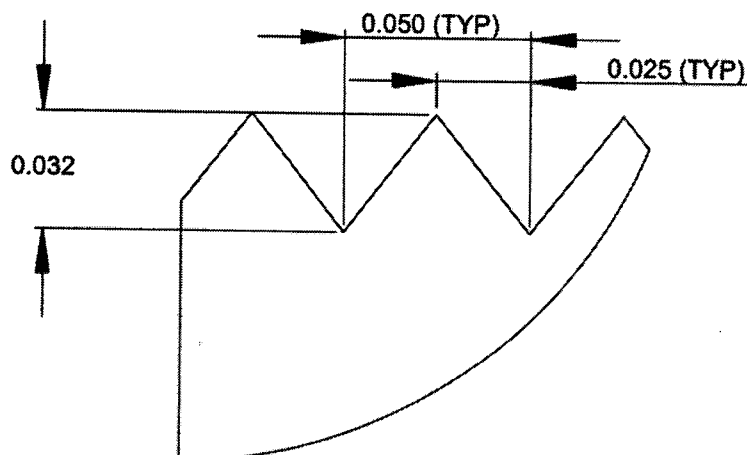


DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED

DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

CERTIFICATE OF COMPLIANCE

RE: 6800-ZZ BEARING

To Whom It May Concern:

Our bearing rings and balls are made of high carbon chromium steel GCr15 which has a chemical composition equivalent to SAE 52100. The hardness of bearing rings is HRC 59-64 and HRC 60-65 for steel balls. Unless specify, bearings are 25-30% filled with Alvania No. 2 grease or Chevron SRI#2 grease or equivalent.

Stella Fan
Phone: 905-629-4255
Fax: 905-629-2358

The logo for SMART SUPPLIES features the word "SMART" in a bold, sans-serif font, with a stylized graphic of three curved lines above the letter "A". Below "SMART" is the word "SUPPLIES" in a similar bold, sans-serif font.

SMART
SUPPLIES